

Work Order ID 58741

Tuesday, May 18, 2010 10:07:22 AM



Page 1

Item ID: D3913-1

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 5/18/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 3.00



Customer:

Reference:Approvals: Process Plan: *H* QC: _____Date: 10-05-18 Tooling: _____ Date: _____
Date: _____ SPC (Y/N): _____ Date: _____Run Start
Stop**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3913 | A |

100



Large Fab

Memo

0.00

(3)

Large Fab

1- Cut tube as per dwg D3913
2- Drill hole as per dwg ***one side only***
3- remove identification marks and deburr

SAO 10-05-31

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S.006101

(X3)

120

Identify as per dwg & Stock Location: *WA*

0.00

Packaging

Memo

0.00

Packaging

SAO

10-05-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 58741

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Page 2

Item ID: D3913-1

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 5/18/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/06/01 HJ

Memo

0.00

CL1016/1

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 18, 2010 10:07:26 AM

Page 1

Work Order ID: 58741



Parent Item: D3913-1



Parent Item Name: Rib

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
add drill one side only DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 3.00

Required Qty: 3.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch Purchased | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|----------------------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M304TS0.750W.049 | | | No | | | 100 | f | 380.4845 | 8 | | | |

304 SQ Tube .75x.75x.049W



SAR

10-05-31

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT | 247.7189789 | |
| 113763 | 0 | |
| 114323 | 46.0489789 | |
| 114677 | 201.67 | 25-2631 |
| MAT017 | 132.7655368 | |
| 113763 | 24.25 | |
| 114298 | 108.515537 | |

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NOTE: Date & initial all entries

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SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

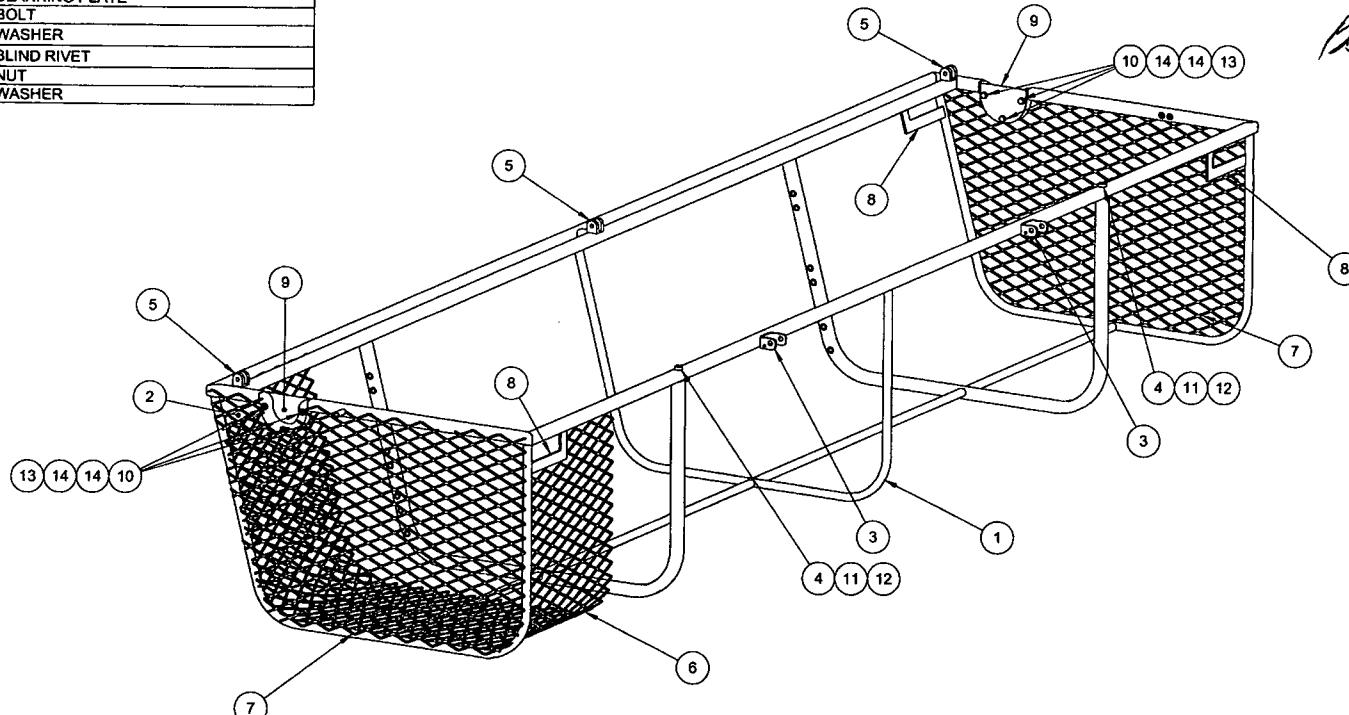
NO. 58741

BB10-5-15

D

D

| ITEM | QTY | P/N | DESCRIPTION |
|------|------|---------------|---------------------------------|
| | -041 | | |
| X | | D3913-041 | LONG BASKET BASE ASSY (350) |
| 1 | 1 | D3913-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 2 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 3 | 2 | D2581 | MOUNTING BRACKET |
| 4 | 2 | D2931 | BUMPER |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-1 | MESH (350 BASKET LONG BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | AN960JD8 | WASHER |
| 12 | 2 | MS20600AD4W3 | BLIND RIVET |
| 13 | 6 | MS21042L3 | NUT |
| 14 | 12 | NAS1149F0332P | WASHER |



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

8

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2

1

| A | NEW ISSUE | JPH | 10.03.16 |
|------------|-------------|---------------------------------|--------------|
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) NTS | |
| DATE | 10.03.16 | | |

RELEASED 2010-03-22 JPH

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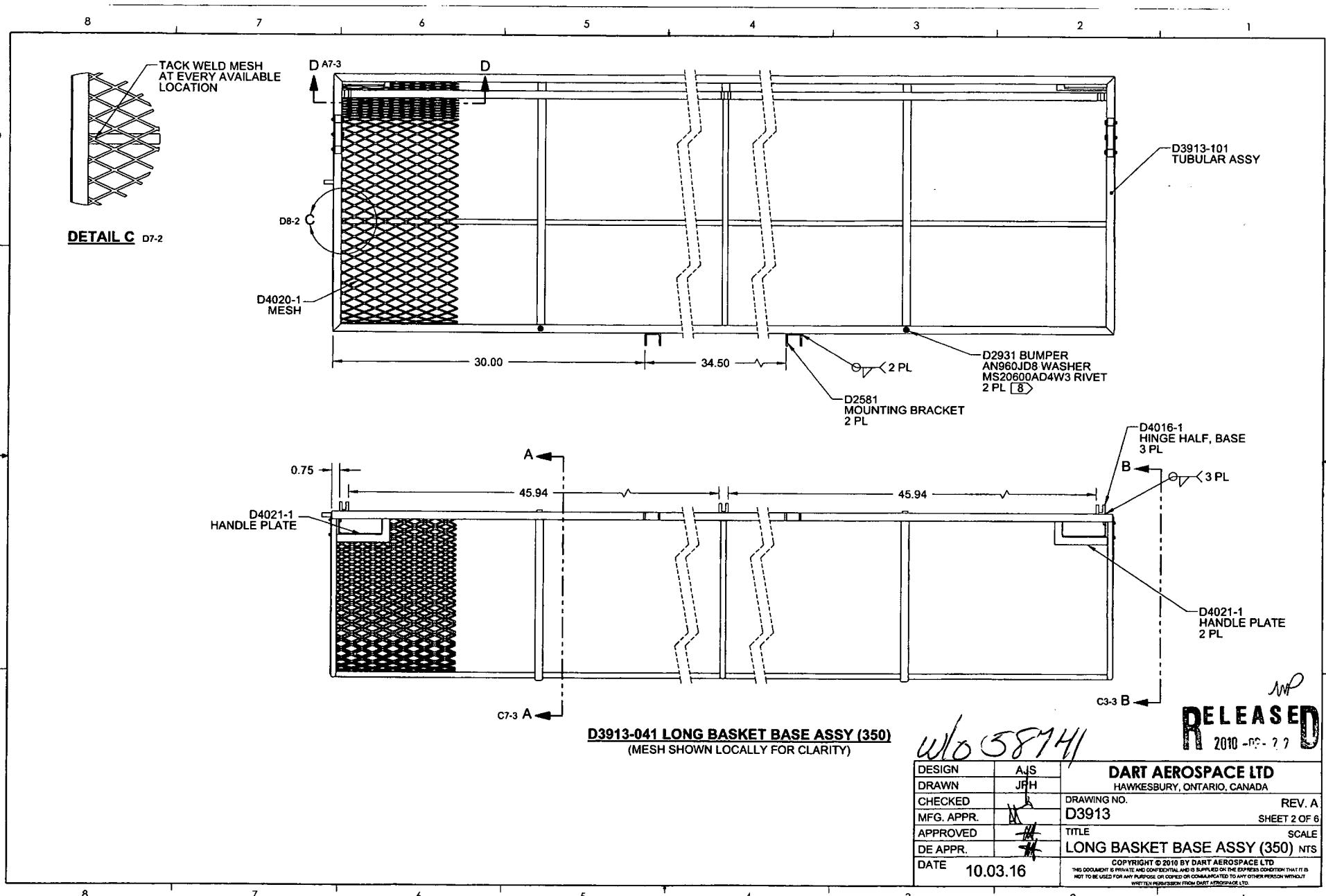
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| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



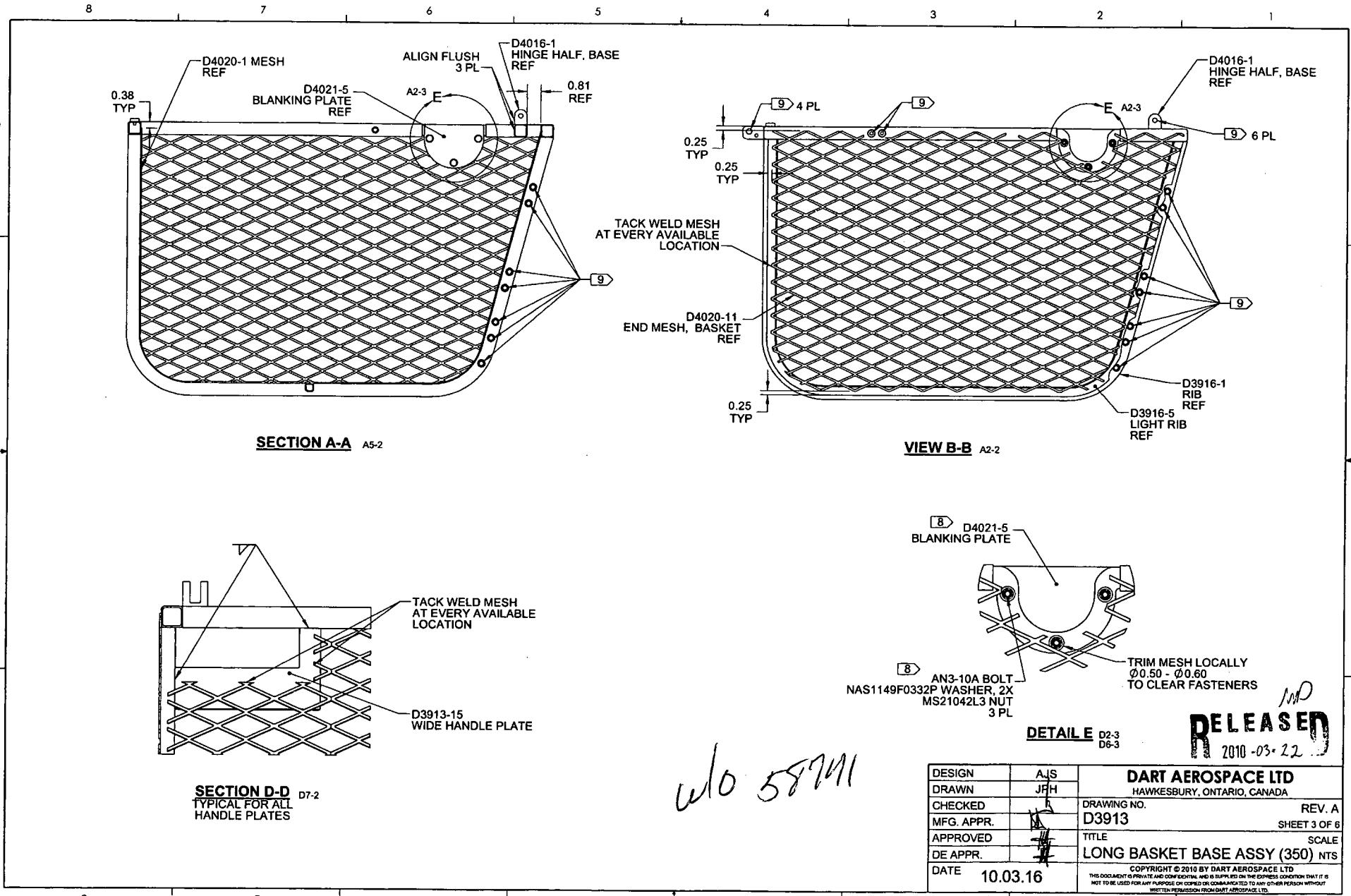
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NOTE: Date & initial all entries



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2010-03-22

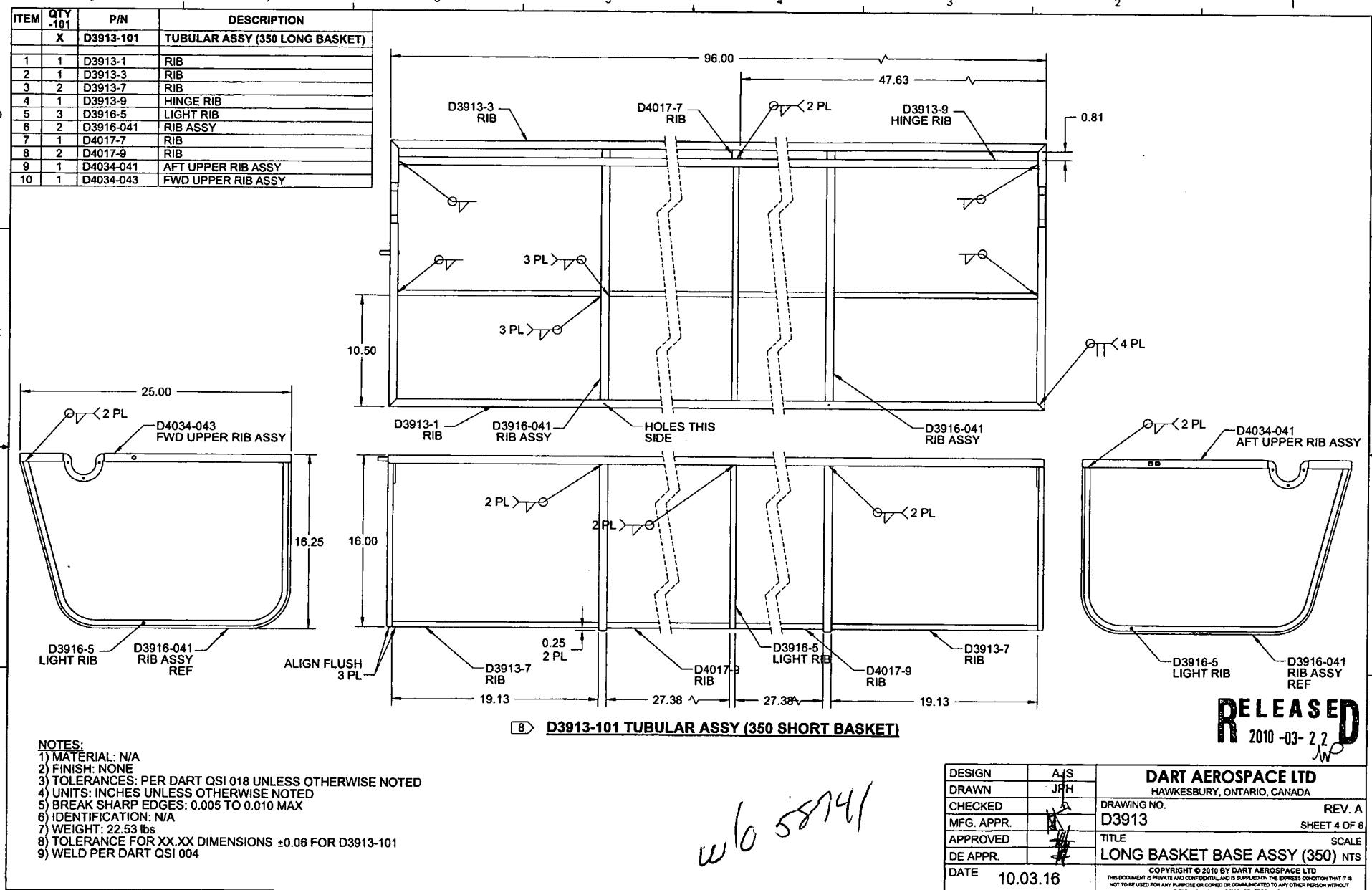
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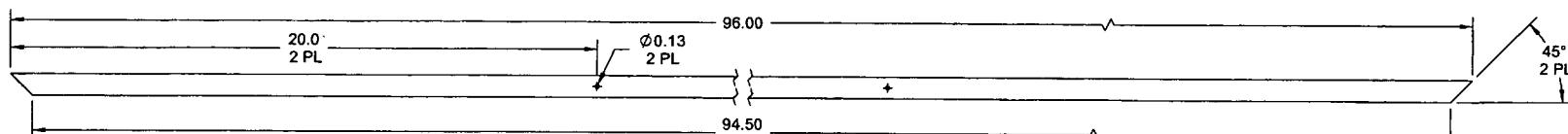
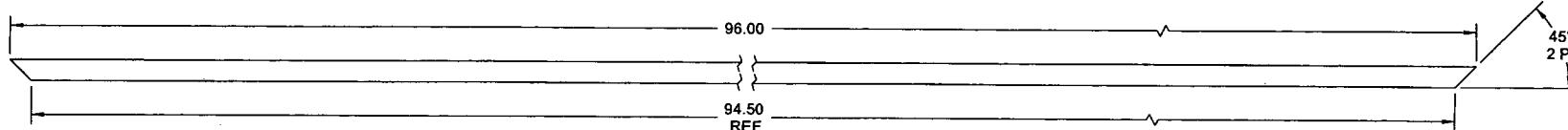
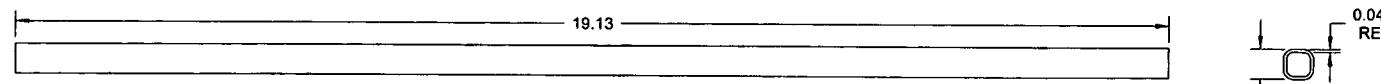
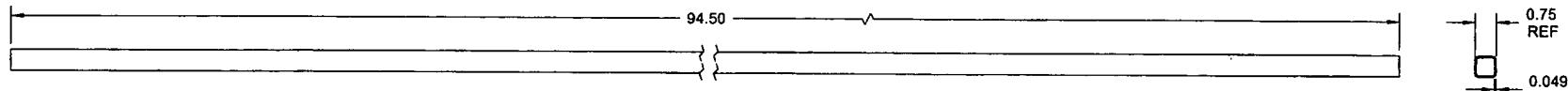
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3913-1 RIBD3913-3 RIBD3913-7 RIBD3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

wb 58741
RELEASED
2010-03-22

| | | | |
|------------|-------------------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[initials]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[initials]</i> | D3913 | SHEET 5 OF 6 |
| APPROVED | <i>[initials]</i> | TITLE | SCALE |
| DE APPR. | <i>[initials]</i> | LONG BASKET BASE ASSY (350) NTS | |
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8 7 6 5 4 3 2 1

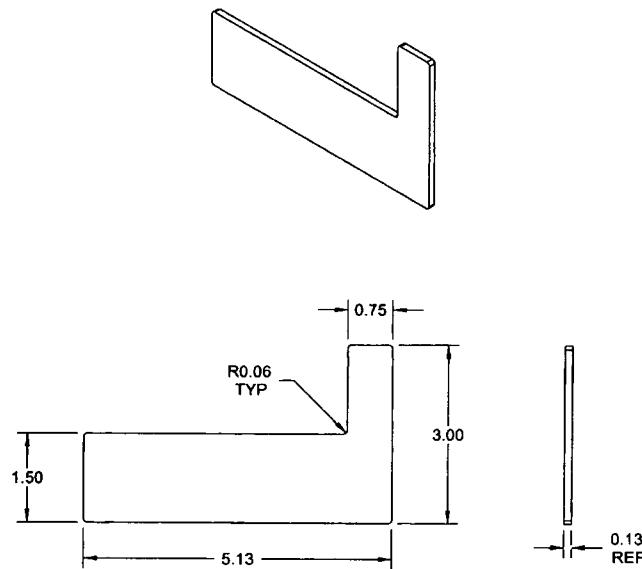
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3913-15 WIDE HANDLE PLATE

w/o 5874

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2010-03-22
JAD

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

8 7 6 5 4 3 2 1

| | | |
|------------|------------------|---|
| DESIGN | AJS | DART AEROSPACE LTD |
| DRAWN | JRH | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[initial]</i> | DRAWING NO. D3913 |
| MFG. APPR. | <i>[initial]</i> | REV. A SHEET 6 OF 6 |
| APPROVED | <i>[initial]</i> | TITLE SCALE |
| DE APPR. | <i>[initial]</i> | LONG BASKET BASE ASSY (350) NTS |
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